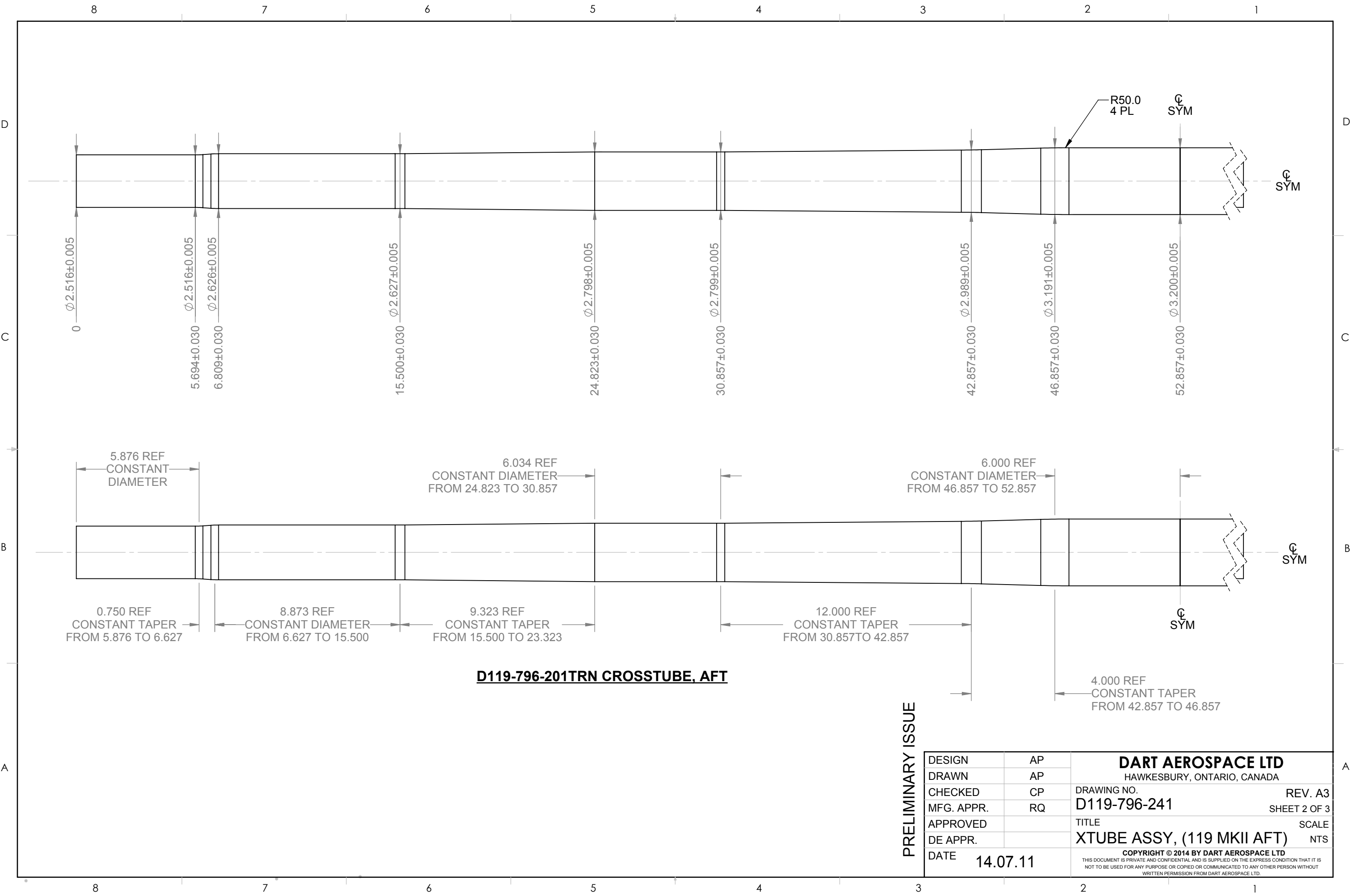


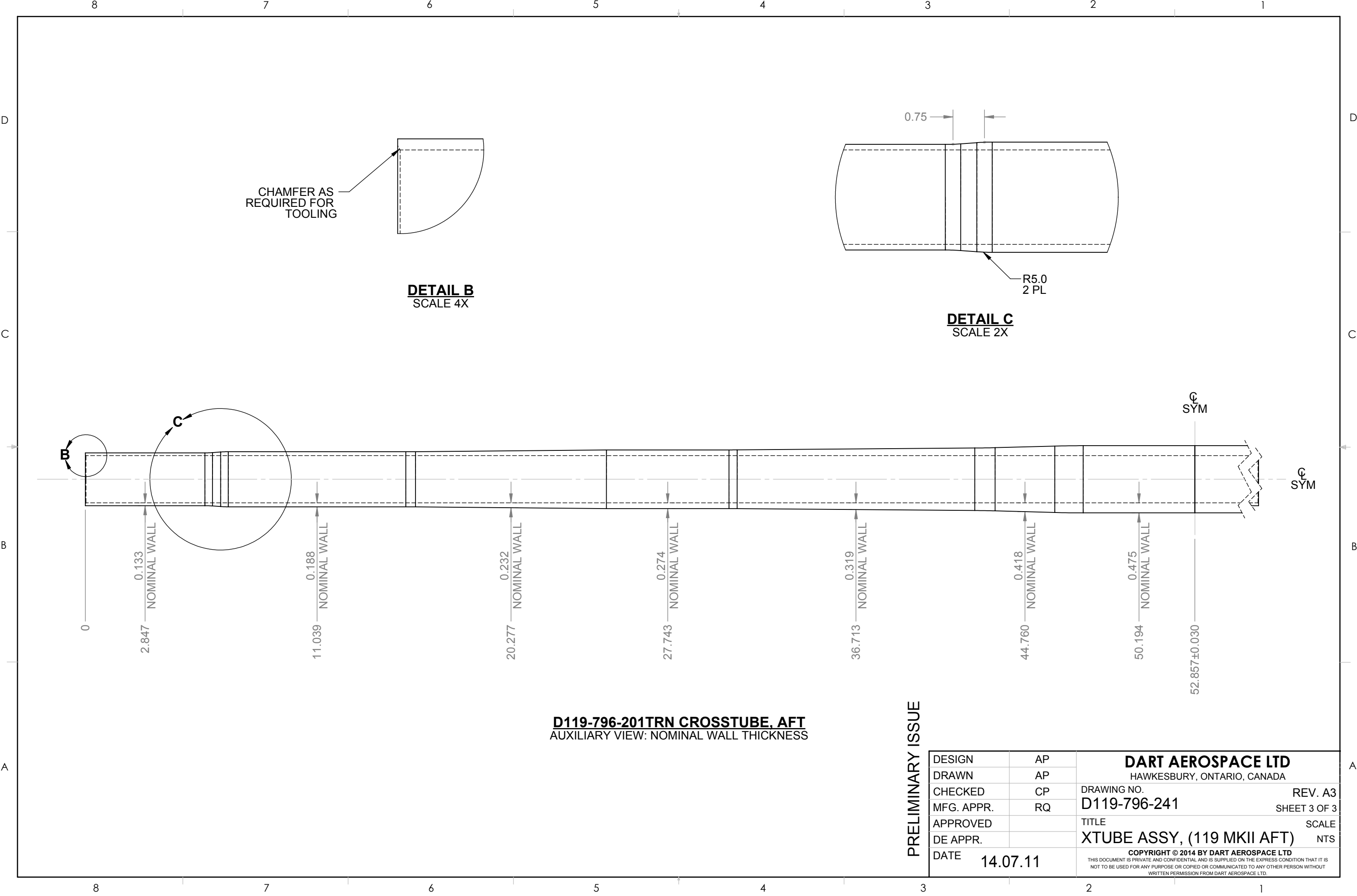
**D119-796-201 CROSSTUBE, AFT** 9  
BENDING AND DRILLING DETAIL

- NOTES:**  
1) MATERIAL: MANUFACTURE FROM D6009-106  
FINISHED LENGTH = 105.71 ±0.020 (BEFORE BENDING/TRIMMING)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 24.17 lbs  
8) PART IS SYMMETRICAL ABOUT CENTERLINE  
9) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 8% BASED ON OD.

PRELIMINARY ISSUE

PA5	ADDED 0.100 TO OD IN TAPER AREA TO HELP REDUCE CRUSHING AND INCREASE STIFFNESS	AP	14.07.11
A	NEW ISSUE	AP	14.05.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A3
MFG. APPR.	RQ	<b>D119-796-241</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>XTUBE ASSY, (119 MKII AFT)</b>	NTS
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PRELIMINARY ISSUE

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A3
MFG. APPR.	RQ	D119-796-241	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		XTUBE ASSY, (119 MKII AFT)	NTS
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